

Work Order ID 137822

October 07, 2015 3:31:12 PM

137822

Page 1

Item ID: D169-841-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: AW169 Lower Cutter

Stop ***NS2***

Start Date: 10/7/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SH Date: 20151007 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D169-841	D

100	Document Control	0.00	DAS 6 9-59						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D169-841-015 CHG002								

1 DAS
28 JAN 06 2016
9-89

ML5 15-12-15

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110									
Packaging	Memo	0.00							
Packaging									

~~DAS~~ DAS
6 27
9-59 9-89 DEC 15 2015

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

120									
QC	Memo	0.00							
Quality Control									

1 DAS
28 JAN 06 2016
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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Item ID: D169-841-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: AW169 Lower Cutter

Stop

NS2

Start Date: 10/7/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
DAS
Number
28
9-89Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D169-841-015

140

0.00

140

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

JAN 06 2016

ME
16-1-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Work Order ID: 137822

137822

Parent Item: D169-841-015

D169-841-015

Parent Item Name: AW169 Lower Cutter

Start Date: 10/7/2015

Required Date: 12/31/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD IPP
REV:B 15.07.03 AS PER CHG002 ecn15-595 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4842-041		Manufactured	No				Each	0.0000		1			
D4842-041	DAS 28 9-89								**	137358			
Lower Cutter Assembly													
MS21042L08		Purchased	No				Each	649.0000		5			
MS21042L08									**	133483			
Nut													

Location Loc Qty Loc Code

CA	101	
m129682	101	
GA	287	
m133134	287	
ST304	261	
123900	16	
m128401	102	
m128429	3	
m131317	26	
m132930	114	

MS27039-08-24		Purchased	No				Each	407.0000		5			
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MS27039-08-24

Screw (MS27039-0824)

Location Loc Qty Loc Code

GA	291	
124326	291	
ST281	116	
125654	116	

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Picklist Print

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Work Order ID: 137822

137822

Parent Item: D169-841-015

D169-841-015

Parent Item Name: AW169 Lower Cutter

Start Date: 10/7/2015

Required Date: 12/31/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

2,617.000

10

NAS1149FN832P

Washer

133709

8-89

BAS 27 9-9

Location

Loc Qty

Loc Code

GA

596

125268

596

ST260a

1000

M133284

500

M133316

500

ST267

100

125268

100

st268

921

M130388

921

**DAS
28
9-89**

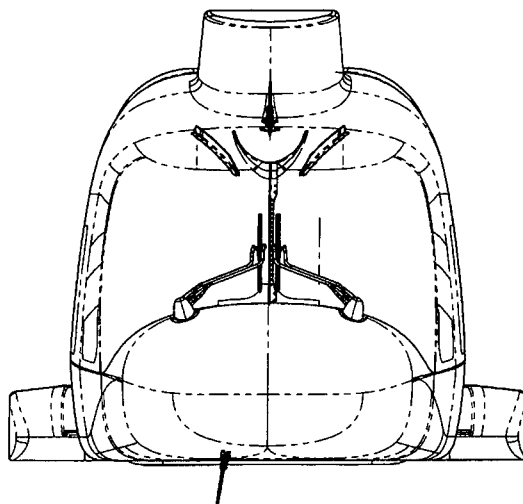
DEC 15 2015

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Shop Packet Print

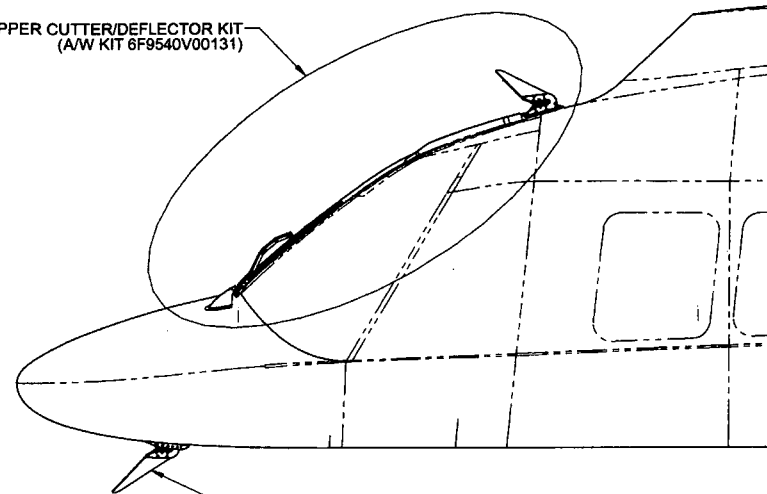
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REFERENCE ONLY



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D169-841-013 UPPER CUTTER/DEFLECTOR KIT
(A/W KIT 6F9540V00131)



D169-841-015 LOWER CUTTER KIT
(A/W KIT 6F9540V00231)

D169-841-011 AW169 CABLE CUTTER SYSTEM

QTY -011	QTY -013	QTY -015	DART P/N	DESCRIPTION	AGUSTA WESTLAND P/N
X			D169-841-011	CABLE CUTTER SYSTEM	TBD
1	X		D169-841-013	UPPER CUTTER/DEFLECTOR KIT	6F9540V00131
1		X	D169-841-015	LOWER CUTTER KIT	6F9540V00231
	1		D4821-1	WINDSHIELD DEFLECTOR	TBD
	1		D4822-1	UPPER DEFLECTOR LH	TBD
	1		D4822-2	UPPER DEFLECTOR RH	TBD
	1		D4840-041	UPPER CUTTER ASSY	TBD
	2		D4857-041	WIPER DEFLECTOR ASSY	TBD
	8		MS27039-1-12	SCREW	N/A
	TBD		TBD	FASTENERS	N/A
		1	D4842-041	LOWER CUTTER ASSY	TBD
		5	MS21042L08	LOCKNUT	N/A
		5	MS27039-0824	SCREW	N/A
		10	NAS1149FN832P	WASHER	N/A

D	MS27039-0824 WAS MS27039-0819. REFORMAT PARTS LIST.	AJS	15.06.12
C	D4857-041 WAS D4857-1 (D4944-1 GASKETS NOW IN D4857 DRAWING). PARTS LIST: MS27039-1-12 QTY WAS 10	AJS	15.05.20
B	ADD D4944-1 GASKET (ZN A8-1) (ZN B6-2, B8-2) ADD MS27039-1-12 SCREW, D4857-1 WAS D4857-041/-042	DW	13.09.23
A	NEW RELEASE	DB	13.07.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	JLM	IIN-D169-841	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	AW169 CABLE CUTTER SYSTEM	NTS
DATE	15.06.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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